

CLAIMS

1. A process for producing an easy-open can lid made of a resin laminated metal sheet comprising laminating a metal sheet or surface-treated metal sheet 5 on one or both resin surfaces thereof with a crystalline saturated polyester resin film having a thickness of 10 to 100 μm , an elongation of at least 150%, a degree of crystallinity of not more than 10%, and a heat of fusion of crystalline of not less than 10 joules/g, to form a 10 laminated metal sheet for an easy-open can, forming by a composite cold-forming method a tear-along groove of a residual thickness of not more than 1/2 of the thickness of the material using top and bottom dies of a die radius of 0.1 to 1.0 mm, then heat treating the crystalline 15 saturated polyester resin layer at the portion surrounding the tear-along groove at a temperature of at least the crystallization starting temperature and less than the melting point thereof.

2. A process for production as claimed in claim 1, 20 wherein the thickness of the resin film laminated on the metal sheet or surface-treated metal sheet is 10 to 80 μm .

3. A process for production as claimed in claim 1, 25 wherein the thickness of the resin film laminated on the metal sheet or surface-treated metal sheet is 16 to 60 μm .

4. A process for producing an easy-open can lid made of a resin laminated metal sheet as claimed in any 30 ^a one of claims 1 to 3, wherein the elongation of the resin film laminated on the metal sheet or surface-treated metal sheet is at least 200%.

5. An easy-open can lid made of a resin laminated metal sheet having resin film properties of an elongation of not more than 100% and a degree of crystallinity of not less than 20% obtained by laminating a metal sheet or surface-treated metal sheet on one or both surfaces thereof with a crystalline saturated polyester resin film 35

having a thickness of 10 to 100 μm , an elongation of at least 150%, a degree of crystallinity of not more than 10%, and a heat of fusion of crystalline of not less than 10 joules/g to form a laminated metal sheet for an easy-
5 open can, forming by a composite cold-forming method a tear-along groove of a residual thickness of not more than 1/2 of the thickness of the material using top and bottom dies of a die radius of 0.1 to 1.0 mm, then heat treating the crystalline saturated polyester resin layer
10 at the portion surrounding the tear-along groove at a temperature of at least the crystallization starting temperature and less than the melting point thereof.

6. An easy-open can lid made of a resin laminated metal sheet as claimed in claim 5, wherein the thickness
15 of the resin film laminated on the metal sheet or surface-treated metal sheet is 10 to 80 μm .

7. An easy-open can lid made of a resin laminated metal sheet as claimed in claim 5, wherein the thickness
20 of the resin film laminated on the metal sheet or surface-treated metal sheet is 16 to 60 μm .

8. An easy-open can lid made of a resin laminated metal sheet as claimed in any one of ~~claims 5 to 7~~^{Claim 5}, wherein the elongation of the resin film laminated on the metal sheet or surface-treated metal sheet is at least
25 200%.

9. A resin laminated metal sheet for an easy-open can lid comprising a metal sheet or surface treated metal sheet laminated on one or both surfaces thereof with a crystalline saturated polyester resin film having a thickness of 10 to 100 μm , an elongation of at least
30 150%, a degree of crystallinity of not more than 10%, and a heat of fusion of crystalline of not less than 10 joules/g.